

Work Order ID 79704

79704

Page 1

January-31-12 3:06:53 PM

Item ID: D3012-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Decal
 Start Date: 31/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 14/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3012	Rev A								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>16054</u>								
	Make as per Dwg D3012								
	Manufacture from 3M 7mil masking film p/n 8522CP								
	Material release note is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

12-02-01
40

12/2/3 (10)

(40)

8/12/10/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79704

Page 2

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 31/01/2012 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 14/02/2012 **Req'd Qty:** 10.00 ***10***

Customer:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop. ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

130

Packaging

Memo

0.00

Packaging

0.00

140

QC

Memo

0.00

Quality Control

10X SP 12-02-06.

12/2/79

1207 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-31-12 3:06:56 PM

Page 1

Work Order ID: 79704

79704

Parent Item: D3012-5

D3012-5

Parent Item Name: Decal

Start Date: 31/01/2012

Required Date: 14/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: Rev A 01.04.06New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3012-5P *D3012-5P* Decal		Purchased	No			110	Each	0.0000	1	10	**	14/2/3 (10)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3012	REV. A SHEET 1 OF 1
DATE 01.03.30		TITLE DECAL	SCALE 1:1
A	01.03.30	NEW ISSUE	

RELEASED
01.04.06 *#*

- POINT A -
SWL=300lb/136kg
DO NOT USE WITH POINT B
P/N D3012-1

D3012-1

- POINT B -
SWL=500lb/227kg
DO NOT USE WITH POINT A OR C
P/N D3012-3

D3012-3

- POINT C -
SWL=300lb/136kg
DO NOT USE WITH POINT B
P/N D3012-5

D3012-5

SHRIMP
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT ORDER
WORK ORDER
NO. 79704 M.L.J
12/01/31

MATERIAL: WHITE LETTERS ON BLACK ADHESIVE BACK
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16054

Purchase Order Date 2/1/2012

PO Print Date 2/1/2012

Page Number 1 of 2

Order From :

VC-STU001

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

Contact Name

Vendor Phone

613 632 5449

Vendor Fax

613 632 9491

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3012-5P	Decal	2/3/2012 Yes	10.00 Each	Yours ppd	\$5.8300	\$58.30
		Special Inst:	3M 7mil masking film p/n 8522CP As per DWG: D3012 Rev: A B79704				
2	D3012-3P	Decal	2/3/2012 Yes	10.00 Each	Yours ppd	\$5.8300	\$58.30
		Special Inst:	3M 7mil masking film p/n 8522CP As per DWG: D3012 Rev: A B79703				
3	D3012-1P	Decal	2/3/2012 Yes	10.00 Each	Yours ppd	\$5.8300	\$58.30

79702

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 2/1/2012

210 Main Street W
Hawkesbury, Ontario K6A 2H6

Invoice No.: 17266
Date: 02/02/2012
Ship Date:
Page: 1
Re: Order No. WO6515

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Dart Aerospace Ltd
Hawkesbury, Ontario

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		10	Autocollant D3012-5P	H	5.83	58.30
		10	Autocollant D3012-3P	H	5.83	58.30
		10	Autocollant D3012-1P	H	5.83	58.30
			PO 16054			
			H - HST 13%			
			HST			22.74
			PST Exempt: #6122-5207			
<div> <div>Studio de Lettrage HST: #825007651 RT0001</div> <div>Shipped By: Tracking Number:</div> <div>Comment:</div> <div>Sold By:</div> </div>						
					Total Amount	197.64

Product & Instruction Bulletin 8522

Release I, Effective September 2008

See Bulletin Change Summary and end of Bulletin

This Bulletin now includes Instruction Bulletin 8522

Scotchcal™ Changeable Opaque Imaging Media 8522

Product Description

Recommended Types of Graphics and End Uses

For Thermal Inkjet Printing

This durable, 7 mil, opaque, changeable film is optimized for use with selected thermal inkjet printers and inks. Ink dries quickly on the film. When overlaminated, it is warranted for medium term, outdoor weatherable graphics, and long term indoor graphics.

When constructed and used as described in this Bulletin, these types of graphics and end uses may be warranted by the 3M™ MCS™ Warranty. Please read the entire Bulletin for details.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics
 - Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

3M specifically does not recommend or warrant the following uses, but please contact us to discuss your needs or recommend other products.

Unsuitable End Uses for This Product

- Not for electronically cut individual letters and numbers
- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wallboard
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.
- Graphics made for automotive Original Equipment Manufacturers (OEM); contact 3M Automotive Division at 1-800-328-1684 for alternatives.

About Water-Based Inkjet Technology

Standard inkjet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this Bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products

3M Graphic Materials

For complete details about graphic construction options, recommended uses and durability, refer to the Product Bulletin for the base film or substrate (media) you are using. See **3M Related Literature** at the end of this Bulletin.

This Bulletin provides details about the base film and construction options and warranty. Additional specific information about compatible products can be found in the Product and Instruction Bulletins listed in **3M Related Literature** at the end of this bulletin.

3M Graphic Materials

For complete details about graphic construction options, recommended uses and durability, refer to the Product Bulletin for the base film or substrate (media) you are using. See **3M Related Literature** at the end of this Bulletin.

Film

- 3M™ Scotchcal™ Opaque Imaging Media 8522

Overlamine

- 3M™ Scotchcal™ Luster Overlamine 8519
- 3M™ Scotchcal™ Matte Overlamine 8520

Printers and Inks

HP Designjet Printers	HP Inks
<ul style="list-style-type: none">• 2500CP and 2000CP• 2800CP and 3800CP• 3500CP and 3000CP• HP Designjet 5000 and 5500	<ul style="list-style-type: none">• Designjet CP Ink System UV (pigment-based)• Designjet CP Inkjet System (imaging ink)
<ul style="list-style-type: none">• Z6100	<ul style="list-style-type: none">• HP 91 Vivera Ink System

Epson Printers	Epson Inks
<ul style="list-style-type: none">• Stylus Pro 9500• Stylus Pro 10000 printer• Stylus Pro 10600 printer	<ul style="list-style-type: none">• Archival Inks

Characteristics

These are typical values for unprocessed product; processing may change the values. Contact your 3M representative for a custom specification.

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness	Media with adhesive: 7.5 to 8 mil (nominal)
Warranted application substrates	See next page.
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Removable	For up to one year; see Warranty Information

Characteristic	Description
Warranted application substrates	<p>Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.</p> <ul style="list-style-type: none"> • Alodine (anodized aluminum) • Automotive panels (automotive painted steel) • Fruehauf (painted aluminum) • FRP (fiberglass reinforced plywood) • Glass • Imron® (polyurethane-painted metal panel) • Acrylic • Sintra™ board <p>Note: Use on any other substrate is strictly on a graphics manufacturer and customer test and approve basis. Test for both adhesion and removal characteristics. The plasticizer in some banner materials may migrate. This may cause the edge of the graphic to peel or lift off of the banner. For optimum performance, follow the guidelines in the section, Creating A Laminated Overlap, on page 4.</p>

Warranty Information

The warranty given in the Product Bulletin that is current at the time you purchased the film is the one that 3M will honor. **The warranties in the following table(s), given in years, are for finished graphics exposed in a vertical exposure in the United States except the Desert Southwest.** See the warranty sections following this table for additional information.

3M™ MCS™ Warranty Durability for Finished Graphics

Construction (film and overlaminates on warranted substrate)	HP Printers & Inks		Epson Printers & Inks		Removal
	Outdoor	Indoor	Outdoor	Indoor	
8522/8519	3 years	5 years	2 years	5 years	1 year without chemical strippers or tools
8522/8520					

Warranty and Limited Remedy

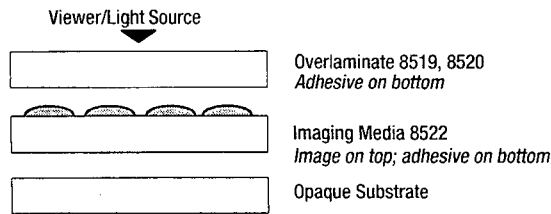
The following is made in lieu of all other express or implied warranties, including any implied warranty of **merchantability** or fitness for a particular purpose or implied warranty arising out of a course of dealing, custom or usage of trade: all 3M products are warranted to be free of defects in materials and manufacture at the time of shipment and to meet the specifications stated in this Product Bulletin. 3M will replace or refund the price of any 3M materials that do not meet this warranty within the specified time periods. These remedies are exclusive. **In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor or non-3M materials charges.**

See the Graphics Market Center Warranty Brochure, which gives the terms, additional limitations of the warranty, if any, and limitations of liability.

Graphic Construction Options

Opaque Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.



Fabrication

Shop Temperature

Acceptable: 60° to 95°F (15° to 35°C)
Optimum: 65° to 73°F (18° to 23°C)

Shop Humidity

Acceptable: 20% to 80%
Optimum: 45% to 60%

Condition the Media Before Use

These steps are especially important if you are operating outside the conditions recommended under Fabrication, above.

- Leave the media in its original packaging until you are ready to condition and use it.
- The day before you need it, remove the media from the box and remove the plastic.
- Condition the media for 24 hours in the same environment as the printer.

Printer Settings for Optimum Quality

Refer to your Hewlett Packard printer manual for detailed operating instructions.

The quality of a printed image depends on a combination of factors: correct media selection, printing software and raster imaging processor (RIP), shop conditions, etc.

The printers qualified to use this media have print mode options that are programmed specifically for these media. Current charts that show the various modes and printing dpi, and the quality results you can expect are available at www.hp.com under the website's support section. We recommend that you print the same image at all of these settings to determine acceptable print and productivity results.

The highest quality settings are usually desirable for backlit applications.

The correct media selection makes most other necessary adjustments to the printer.

- For the HP DesignJet CP 2000 or 3000 series printers, select the **Opaque Vinyl UV** setting.
- For the HP Designjet 5000 series printers, select the **3M Changeable UV** setting or the HP **Durable Gloss UV** or HP **Colorfast Vinyl** setting.
- For the Z series printers, refer to HP's website or printer manuals.

Note: The HP printer settings lay down less ink per pass, which results in better ink absorption and quicker drying times.

- For the HP DesignJet CP 2000 or 3000 series printers, select the **Opaque Vinyl UV** setting.
- For the HP Designjet 5000 series printers, select the **3M Changeable UV** setting or the HP **Durable Gloss UV** or HP **Colorfast Vinyl** setting.
- For the Z series printers, refer to HP's website or printer manuals.

Note: The HP printer settings lay down less ink per pass, which results in better ink absorption and quicker drying times.

Drying Guidelines

Usually, the media can be laminated within 10 minutes after printing. However, especially in high humidity conditions, we recommend waiting 15 to 30 minutes before laminating.

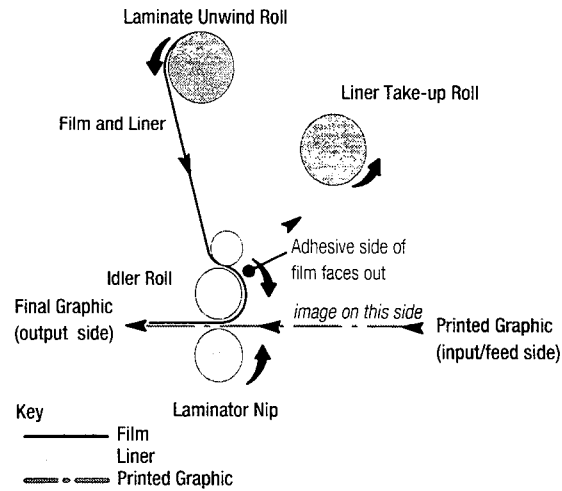
Use care when handling graphics that have not been laminated to avoid scratching and abrasion.

Graphics made with this media and ink combination typically may be wound directly on a take-up roll after printing.

Overlamine

Whether or not you want a warranted graphic, an overlamine is recommended to enhance durability, especially in outdoor applications.

FIGURE 1
Typical Laminator Thread-up



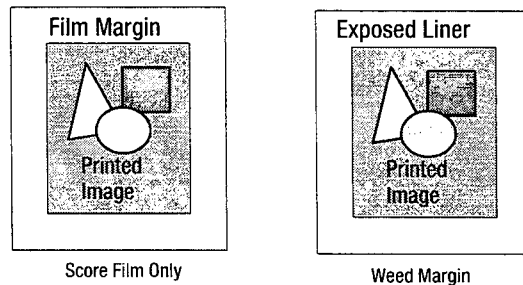
Creating a Laminated Overlap

Creating a laminated overlap helps ensure that the graphic does not peel or lift away from certain banner materials that may be subject to plasticizer migration. This method may also be used for flat, rigid or flexible sign applications.

1. Print the graphic as usual.
2. On all sides of the graphic, score *the film only* to the correct, final graphic dimension *without cutting through the liner*.

Weed away the excess film, leaving the bare liner exposed around the graphic. See FIGURE 2.

FIGURE 2
Trim and Weed Film Margin Only



3. Laminate the graphic as usual (see page 5), making sure that at least one inch of the bare liner is covered by the laminate. See FIGURE 3.